

Date: Tuesday, 1/31/2006 11:07:08 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DUMP OUTLET
Job Number :	25688		
Estimate Number :	12131		
P.O. Number :	N/A	Part Number :	D34757
This Issue :	1/31/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3475 REV A
First Issue :	N/A	Project Number :	N/A
Previous Run :	N/A	Drawing Revision :	A
	Type :	Material :	N/A
	SMALL / MED FAB	Due Date :	2/21/2006
Written By :	Qty:		10 Um: Each
Checked & Approved By :	See comment below		
Comment :	06-01-31		
	Est Revis New Issue 06-01-31 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 489 For D3475-7S

Spin as per Dwg D3475

Possible Supplier: SIEG

Material release note is required

u 06-02-01 10

2.0	D34757S	scoop outlet
-----	---------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 scoop outlet

(10)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

Pc 6/2/24 (10)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Pc 6/2/27 10

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

(10)

1-Scribe line at .180" Below center line of part

2-Rough Cut Part on Band Saw Leaving some Material.

ml 06/03/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/31/2006 11:07:08 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUMP OUTLET

Job Number: 25688

Part Number: D34757

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Using DT8842 Angle Block,Sand Part on Disk Sander to Scribed line.

4-Transfer Punch Using DT8843,Then Drill as per Dwg D3475.

5-Deburr.

ml 06/03/06 PTO
8

6.0

QC5

INSPECT WORK TO CURRENT STEP



06-03-22 8

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

06-03-28 8

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/03/30 8

Job Completion



06-03-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

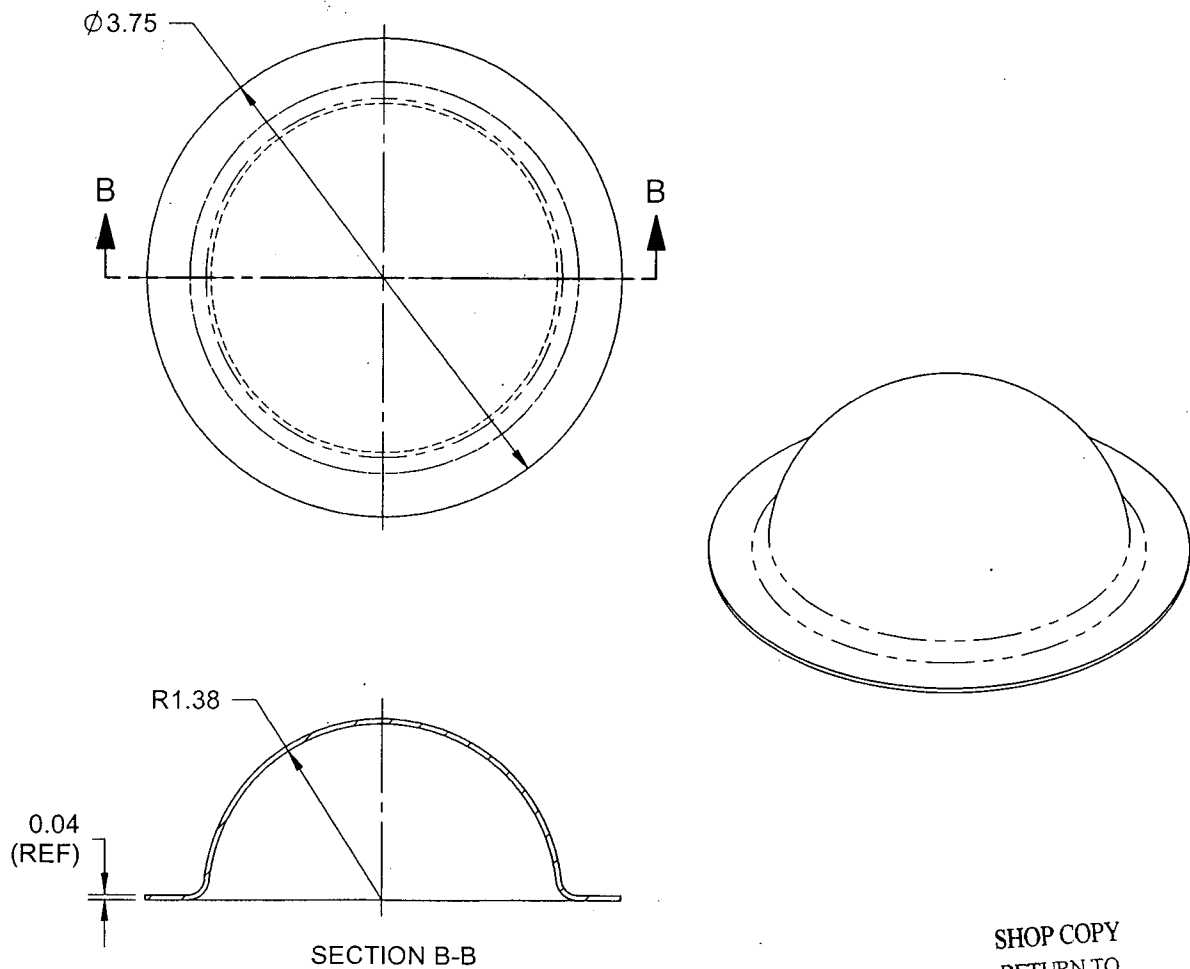
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: Date: 06/07/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/03/06	5	Found 9 pieces only and Scrap!	<u> </u> Q&P	Total of Scrap # 1 No replace 1 part used for template.	<u>mlf</u> 06/03/06	<u> </u> 06-03-29	<u> </u> Q&P	<u> </u> 06-03-29

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3475	REV. A SHEET 5 OF 6
DATE 06.01.24		TITLE DUMP OUTLET	SCALE 1:1.5



D3475-7S SCOOP OUTLET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25688

NOTES:

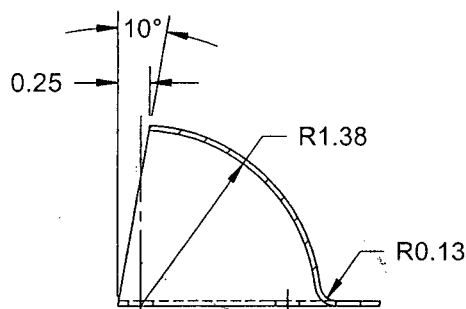
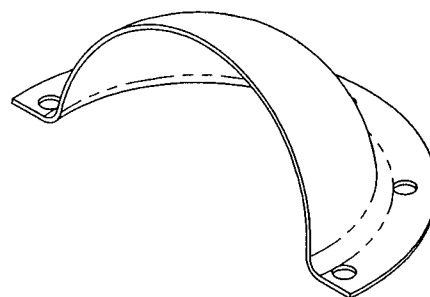
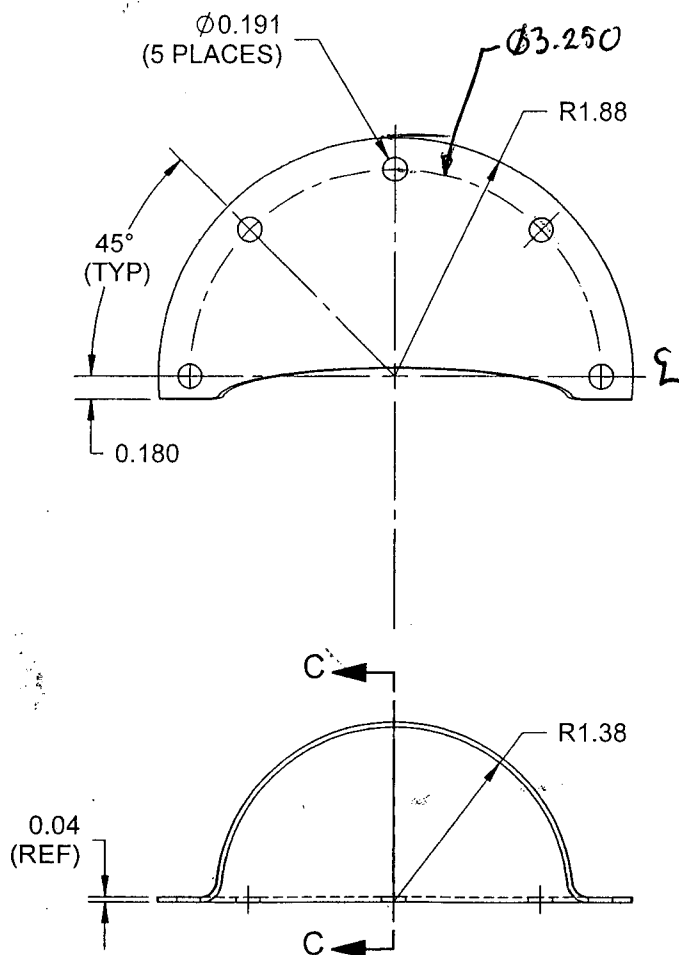
- 1) MATERIAL: 2024-0 ALUMINUM SHEET, 0.040" THICK PER AMS-QQ-A-2505/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.040)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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PRELIMINARY ISSUE

DESIGN 3	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3475	REV. A SHEET 6 OF 6
DATE 06.01.24		TITLE DUMP OUTLET	SCALE 1:1.5



SECTION C-C

D3475-7 SCOOP OUTLET

NOTES:

- 1) MATERIAL: MAKE FROM D3475-7S
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
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WORK ORDER
NO. 25688



Sieg's Manufacturing Ltd.

604 530-7455 fax 604 530-7490
6236-205 Street, Langley, British Columbia, Canada. V2Y 1N7



INSPECTION REPORT

DATE: Feb. 23/06

CUSTOMER: Dart Aerospace

INVOICE #: P5#29917 SUPPLIER #: Sieg's

DESCRIPTION OF INSPECTION: D3475 Cap. Size/metal

PART #	QTY.	MATERIAL	CHECK HOLES	DEBUR EDGES	INSP BY
D3475-whole	10	✓	N/A	✓	
D3476	10	Wrong	N/A	✓	

NOTES OF INSPECTION: good

NOTES OF REJECT: wrong material used for D3476
will redew!

P-0489

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA

DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Karton P. Young

Karton P. Young
Quality Assurance Manager

205131
Ship Date

2003-01-10

P.O. No./Govt Contract No.

8G6265

9050
B.L. No.

24546

Invoice No.

56912

Customer

C&B-WALLINGFORD

Alcoa No. Item

DS-56734-1

Page 1

Ship To: COPPER & BRASS SALES INC
WALLINGFORD BRANCH
5 STERLING DRIVE
WALLINGFORD, CT 06492

Item Description

.040 IN TK (+.0000 -.003) X 48 IN W X 144
IN LN (N) A/T ALCLAD 2024-O FLAT SHEET MILL FINISH (PART 752603-
1) RAWMA 02-182-030. PER(EXC GA TOL) AMS-QQ-A-
250/5 REV A & EXCEPT MARKING
ASTMB209 REV 02 & EXCEPT MARKING AMS4040 REV M
((MARKED)) INTERLEAVED MAX GROSS
SKID WGT: 2400 LB QUAN TOL +/-30 %
CQR 0137587 REV 01 QRR 000879 CUST REQ 02-12-
15 *** W/E 02-12-21 ***

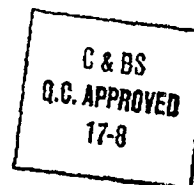
Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	639714	533531	2035	77	PC	
2	639810	533531	795	30	PC	
3	639812	533531	2011	77	PC	
4	639813	533531	2115	81	PC	
5	639814	533531	2039	77	PC	
			8995	342		

Notes for CQR: 0137587.1

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/5 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/5F, AMENDMENT 2.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/5F, AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/5.

CQR: 0137587.1 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
O	Long Transv.	KSI	KSI	PCT
	Max	30.0	14.0	
	Min			12
Temp	Dir	UTS	TYS	EL4D
T42	Long Transv.	KSI	KSI	PCT
	Max			
	Min	57.0	34.0	15
Temp	Dir	UTS	TYS	EL4D
T42P	Long Transv.	KSI	KSI	PCT
	Max			
	Min	57.0	34.0	15



SIKORSKY

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DAVENPORT WORKS

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C&B-WALLINGFORD

Ship From: RIVERDALE, IA.

Alcoa No. Item

DS-56734-1

Page 2

CQR: 0137587.1 -Specification Limits (cont.)

Temp	Dir	Max	Min	UTS KSI	TYS KSI	EL4D PCT
T62	Long Transv.			60.0	47.0	5

Chemical Composition	Max	Min	SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 2024			.50	.50	4.9	.9	1.8	.10	.25	.15	.05	.15	
					3.8	.30	1.2						REMAIN

Chemical Composition	Max	Min	SI+FE	CU	MN	MG	V	ZN	TI	Other Each	Aluminum
LINER			.70	.10	.05	.05	.05	.10	.03	.03	
Alloy 1230											99.30

Lot: 533531 -Mechanical, Physical, Metallography, Quantometer Results



Temp	Dir	No. Test	Max	Min	UTS KSI	TYS KSI	EL4D PCT
0	Long Transv.	2			23.4	11.5	20
					23.4	11.4	20

Temp	Dir	No. Test	Max	Min	UTS KSI	TYS KSI	EL4D PCT
T42	Long Transv.	2			60.8	37.6	24.5
					60.5	37.5	19.5

Temp	Dir	No. Test	Max	Min	UTS KSI	TYS KSI	EL4D PCT
T42P	Long Transv.	2			62.5	38.4	27
					62.4	38.2	25

Temp	Dir	No. Test	Max	Min	UTS KSI	TYS KSI	EL4D PCT
T62	Long Transv.	2			61.8	49.4	9.5
					61.6	48.9	9

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PITTSBURGH, PA DAVENPORT WORKS

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DS-56734-1

Page 3

2003-01-10

24546

P.O. No./Govt Contract No.

Customer

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C&B-WALLINGFORD

Lot: 533531 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----

Cast Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
H9532015	Actuals	.07	.17	4.6	.64	1.6	.01	.10	.03